

Work Order ID 95032

95032

Page 1

January-02-13 12:48:40 PM

Item ID: D4640-15

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Ceiling Protector

Start Date: 1/02/13

Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/18/13

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 13-01-03 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4640	C								
100		0.00							
100									
Waterjet									
FLOW CNC Waterjet									
	Memo	0.00							
	***Confirm if parts are trimmed or untrimmed prior to cutting ***								
	Cut as per dwg								
	Prog Rev: <u>C</u>								
	Dwg Rev: <u>C</u>								
	Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC									
Quality Control									

2
X

0

Jm 13-1-15
RB 1-13

Pto

2
X

0





Jm 13-1-15
RB 1-13

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AKH Date: 23/01/23QA Closed: AKH Date:

Work Order: <u>95032</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4640-15</u>		Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input checked="" type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
NCR No. <u>13-2240</u>					

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									
	13/1/18	100	2	PARTS DON'T MATCH TEMPLATE. PROBLEM WITH PROGRAM.	 13/1/18	Acceptable. Ref attached email.	 13/1/18	 13/1/23	 13/1/23

FAULT CATEGORY

Landing Gear	General
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged
<input type="checkbox"/> Crushed/Crimped.	<input type="checkbox"/> Burrs
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio
	<input type="checkbox"/> Grain
	<input type="checkbox"/> Hardware
	<input type="checkbox"/> Inspection Incomplete
	<input type="checkbox"/> Instructions Incomplete/Unclear
	<input type="checkbox"/> Maintenance
	<input type="checkbox"/> Mislabeled
	<input type="checkbox"/> Misread
	<input type="checkbox"/> Offset
	<input type="checkbox"/> Out of Calibration
	<input type="checkbox"/> Out of Sequence
	<input type="checkbox"/> Outside Dimensions
	<input type="checkbox"/> Ovalized
	<input type="checkbox"/> Over/Under tolerance
	<input type="checkbox"/> Part Incorrect
	<input type="checkbox"/> Part Lost/Missing
	<input type="checkbox"/> Part Moved
	<input type="checkbox"/> Positioned Wrong
	<input type="checkbox"/> Power Loss/Surge
	<input type="checkbox"/> Pressure/Forced
	<input type="checkbox"/> Temperature/Cure
	<input type="checkbox"/> Weld
	<input type="checkbox"/> Wrong Stock Pulled
	<input type="checkbox"/> Other

95032

January-02-13 12:48:40 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/02/13 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 1/18/13 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID**Tool #**

Plan Code

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

QC8- Inspect parts - second check

0.00

120

QC

Quality Control

Memo

0.00

USE TEMPLATE TO MARK HOLE LOCATIONS WITH A FINE POINT MARKER ON TEXTURED SIDE

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Packaging

Memo

0.00

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

January-02-13 12:48:40 PM

Page 1

Work Order ID: 95032

Parent Item: D4640-15

Parent Item Name: Ceiling Protector

Start Date: 1/02/13

Required Date: 1/18/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC
REV.B VERF:JLM

IPP REV:B 12.10.17 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	3,794.7600	12.6	26.526316		Jm 13-1-15 13-1-13	
GE PLASTICS LEXAN SHEET													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT023	3794.76	
112176	30.1	
114459	1100.66	
123105	2664	

~~114459~~
123105
(2)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructor's Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

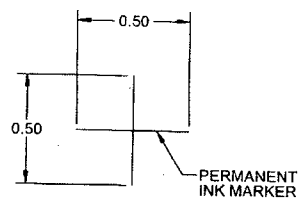
DART AEROSPACE LTD		Work Order:	95032
Description: Ceiling Protector		Part Number:	D4640-15
Inspection Dwg: D4640	Rev: 5	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

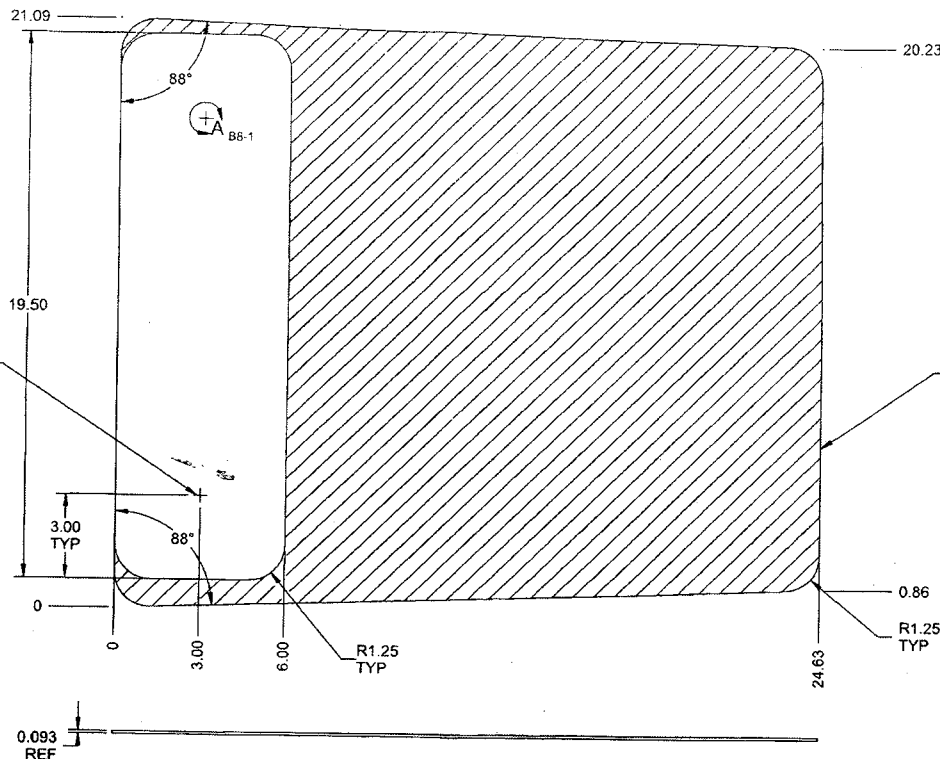
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.80	+/-0.030	18.80	2		T 1801	
22.03	+/-0.030	22.03	2		T	
20.06	+/-0.030	20.06	2		T	
13.06	+/-0.030	13.06	2		T	
3.60	+/-0.030	3.609	2		T	
8.09	+/-0.030	N/A				
20.86	+/-0.030	N/A				
3.11	+/-0.030	N/A				
7.27	+/-0.030	N/A				
5.10	+/-0.030	N/A				
4.85	+/-0.030	N/A				
13.06	+/-0.030					
1.50	+/-0.030	1.490	2		V 1807	
5.00	+/-0.030	5.007	2		V	
57.46	+/-0.030	57.46	2		T	
82.37	+/-0.030	82.37	2		T	
Ø8.13	+0.012/-0.001	8.129	2		V	
6.77	+/-0.030	N/A	2		T	
5.72	+/-0.030	N/A	2		T	
6.13	+/-0.030	N/A	2		T	
2.21	+/-0.030	N/A	2		T	
0.68	+/-0.030	N/A	2			
7.78	+/-0.030	7.781	2		V	
7.47	+/-0.030	7.486	2		V	
Ø0.375	+0.006/-0.001	.374	2		V	
9.73	+/-0.030	9.73	2		V	
21.00	+/-0.030	21.00	2		T	
31.28	+/-0.030	31.28	2		T	
4.00	+/-0.030	N/A				
27.23	+/-0.030	N/A				
22.28	+/-0.030	N/A				
20.36	+/-0.030	20.36				
0.093	+/-0.010	.094	2		V	

Measured by: B	Audited by: 15	Preliminary Approval:
Date: 13-1-13	Date: 13-1-13	Date:

Rev	Date	Change	Revised by	Approved
A	12.09.26	New Issue	KJ	



DETAIL A
NOT TO SCALE
TRIMMED KIT ONLY



D4640-1 RH FORWARD WALL PROTECTOR
TEXTURED SIDE SHOWN

NOTES:

- 1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXX.093-F6006-07
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 2.01 lbs (TRIMMED WEIGHT = 0.47 lbs)
- 8) CHECK PER TEMPLATE DT8924
- 9) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER:
- DRAW 0.50" CROSS ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER
- TRIM AND REMOVE SHADED AREA

NO. 95032MLJ
13-01-03

RELEASED
2012-11-29

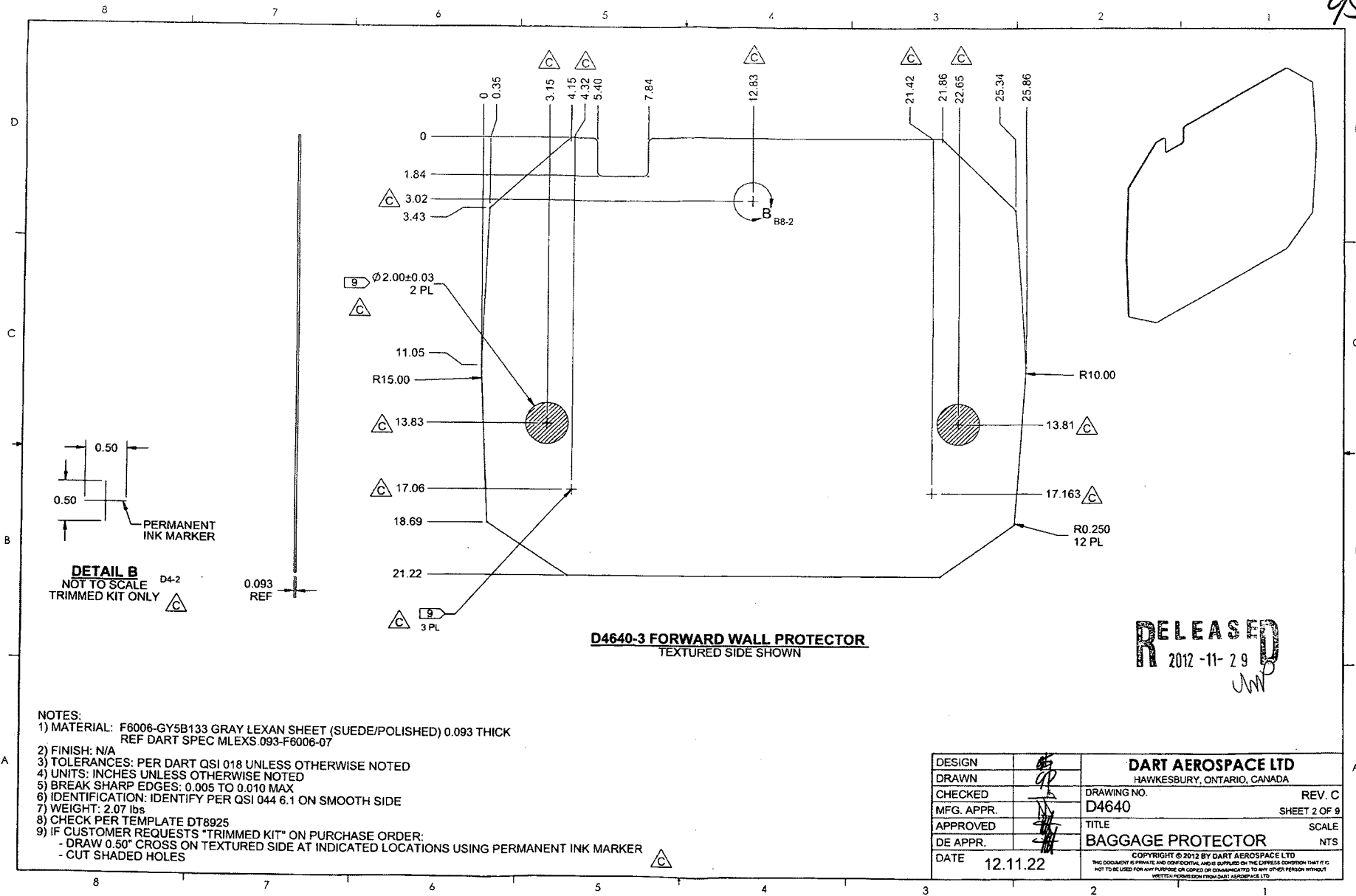
C	REMOVED HOLES AND REPLACED WITH REF MARKS, -3/-7: HOLEMARK LOCATIONS REVD PER CUSTOMER REQUEST	CP	12.11.22
B	CHANGE MATERIAL FROM F6006-701 BLACK LEXAN TO F6006-GY5B133 GRAY LEXAN AND ADD HOLES, ADD -1 TRIMMED, -15 CENTERLINE SHIFTED, DIMENSIONS CHANGED, PART UNCHANGED.	DC	12.07.19
A	NEW ISSUE	DC	12.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.11.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4640** REV. C
SHEET 1 OF 9
TITLE **BAGGAGE PROTECTOR** SCALE NTS

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95032



DETAIL B
NOT TO SCALE
TRIMMED KIT ONLY
D4-2
PERMANENT
INK MARKER

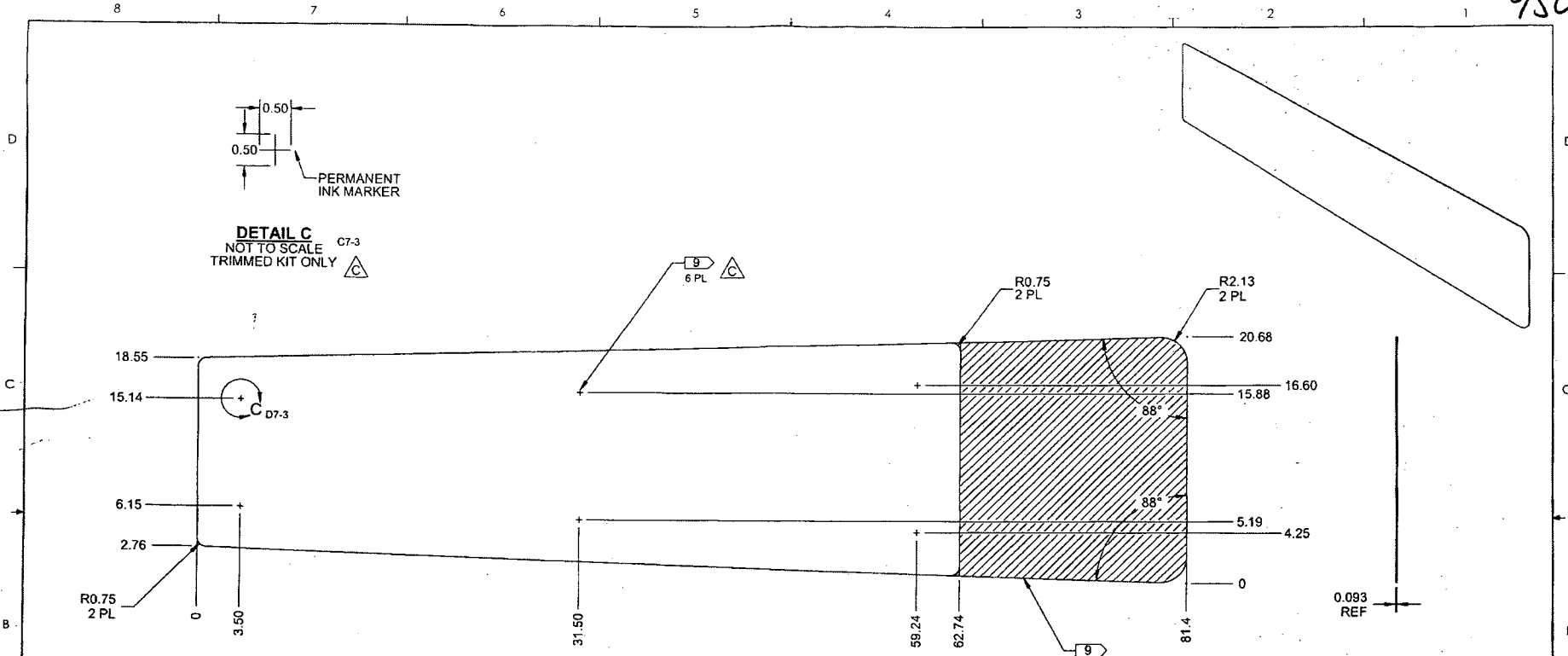
D4640-3 FORWARD WALL PROTECTOR
TEXTURED SIDE SHOWN

RELEASED
2012-11-29
JW

- NOTES:**
- 1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
 - 7) WEIGHT: 2.07 lbs
 - 8) CHECK PER TEMPLATE DT8925
 - 9) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER:
- DRAW 0.50" CROSS ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER
- CUT SHADED HOLES

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D4640 SHEET 2 OF 9
APPROVED		TITLE SCALE
DE APPR.		BAGGAGE PROTECTOR NTS
DATE	12.11.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. UNLESS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

95032



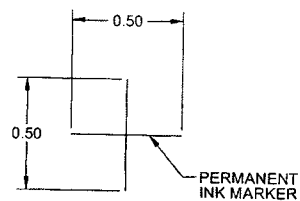
D4640-5 LH WALL PROTECTOR
TEXTURED SIDE SHOWN

RELEASED
2012-11-29
WJ

- NOTES:
- 1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
 - 7) WEIGHT: 6.00 lbs (TRIMMED WEIGHT = 4.49 lbs)
 - 8) CHECK PER TEMPLATE DT8926
 - 9) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER:
- DRAW 0.50" CROSS ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER
- TRIM AND REMOVE SHADED AREA

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4640	SHEET 3 OF 9
APPROVED		TITLE	SCALE
DE APPR.		BAGGAGE PROTECTOR	NTS
DATE	12.11.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

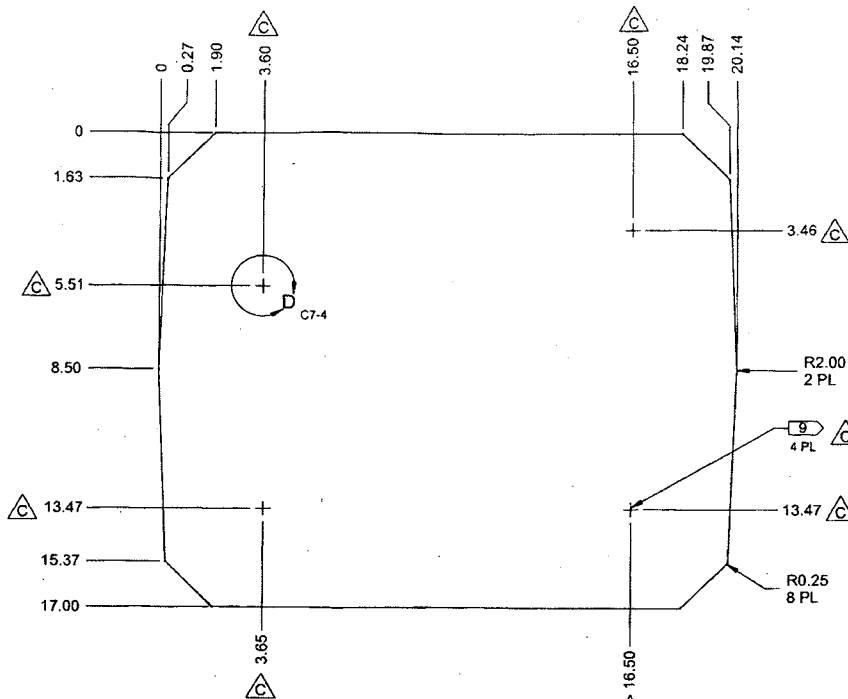
95032



DETAIL D
NOT TO SCALE
TRIMMED KIT ONLY

C5-4

0.093
REF



D4640-7 AFT WALL PROTECTOR
TEXTURED SIDE SHOWN

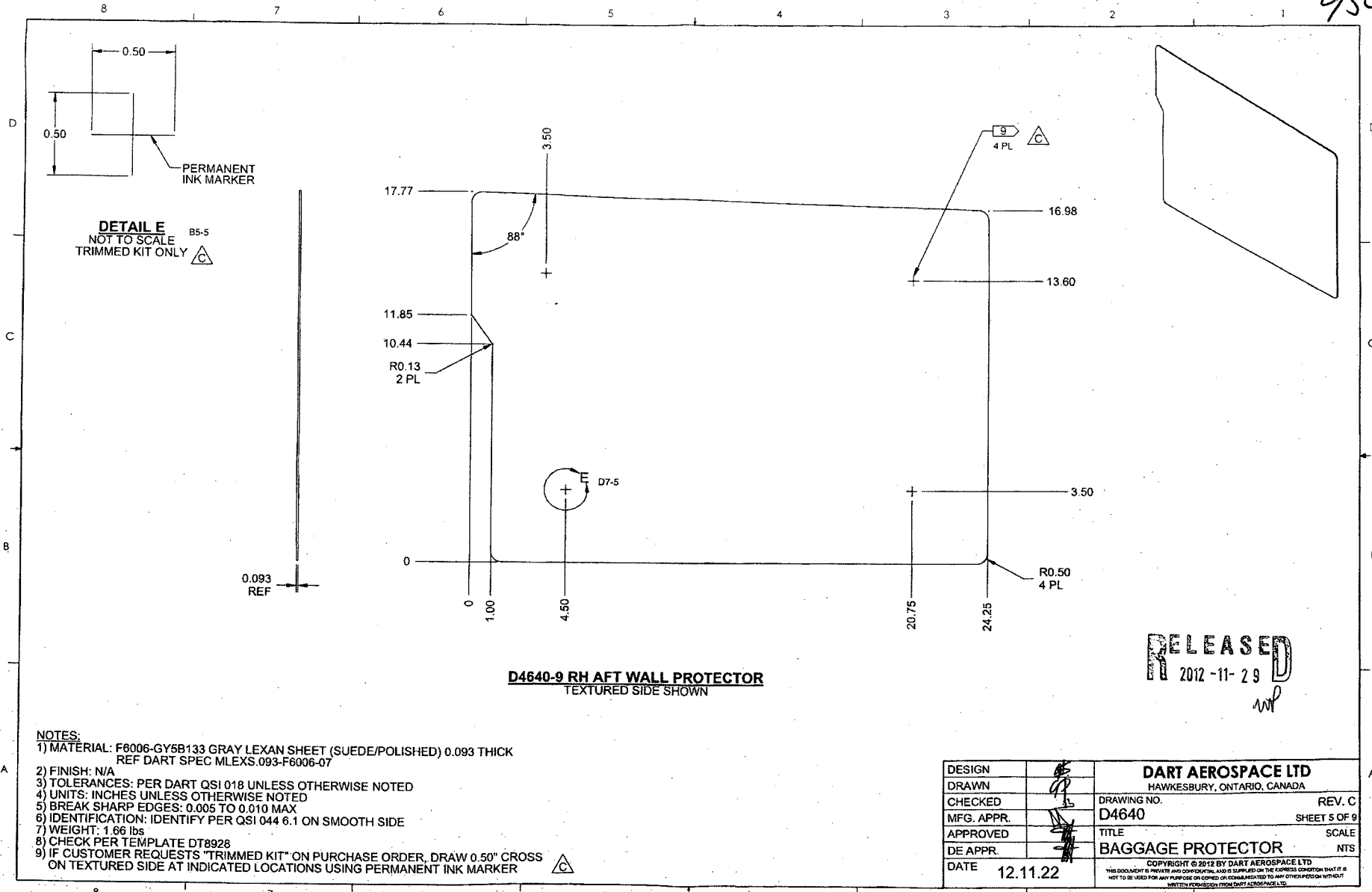
RELEASED
2012-11-29

NOTES:

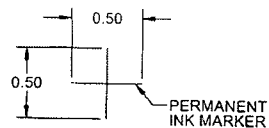
- 1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 1.34 lbs
- 8) CHECK PER TEMPLATE DT8927
- 9) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER, DRAW 0.50" CROSS
ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4640	SHEET 4 OF 9
APPROVED		TITLE	SCALE
DE APPR.		BAGGAGE PROTECTOR	NTS
DATE	12.11.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

95032

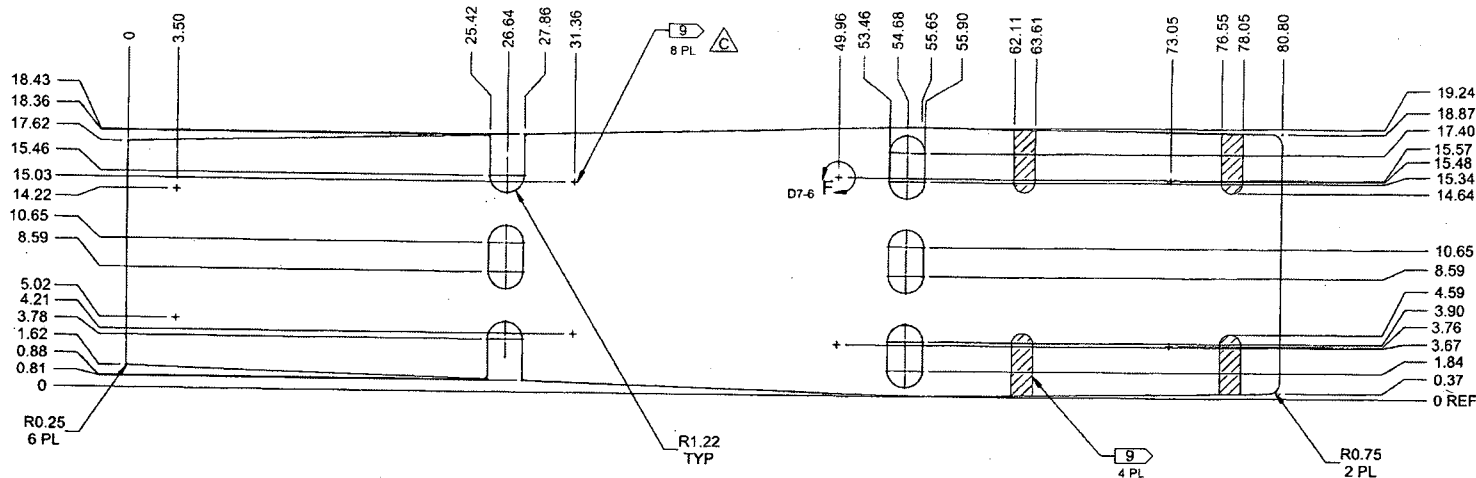


95032



DETAIL F
NOT TO SCALE
TRIMMED KIT ONLY

C5-6



D4640-11 FLOOR PROTECTOR
TEXTURED SIDE SHOWN

NOTES:

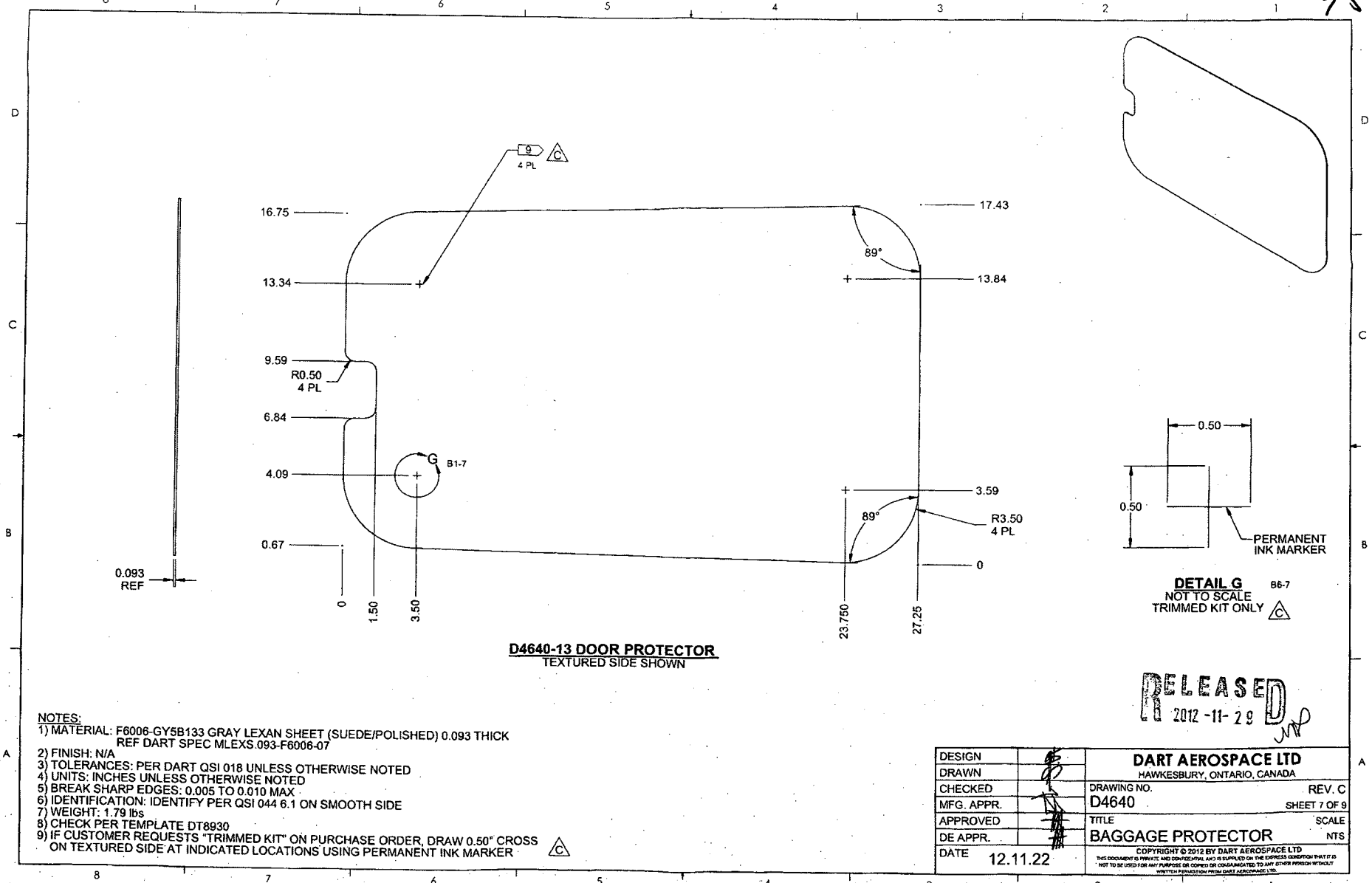
- 1) MATERIAL: F6006-GY58133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 5.66 lbs (TRIMMED WEIGHT = 5.55 lbs)
- 8) CHECK PER TEMPLATE DT8929
- 9) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER:
- DRAW 0.50" CROSS ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER
- TRIM AND REMOVE SHADED AREA



RELEASED
2012-11-29
JMM

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4640
MFG. APPR.		REV. C
APPROVED		SHEET 6 OF 9
DE APPR.		TITLE BAGGAGE PROTECTOR
DATE	12.11.22	SCALE NTS
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95032



D4640-13 DOOR PROTECTOR
TEXTURED SIDE SHOWN

DETAIL G
NOT TO SCALE
TRIMMED KIT ONLY

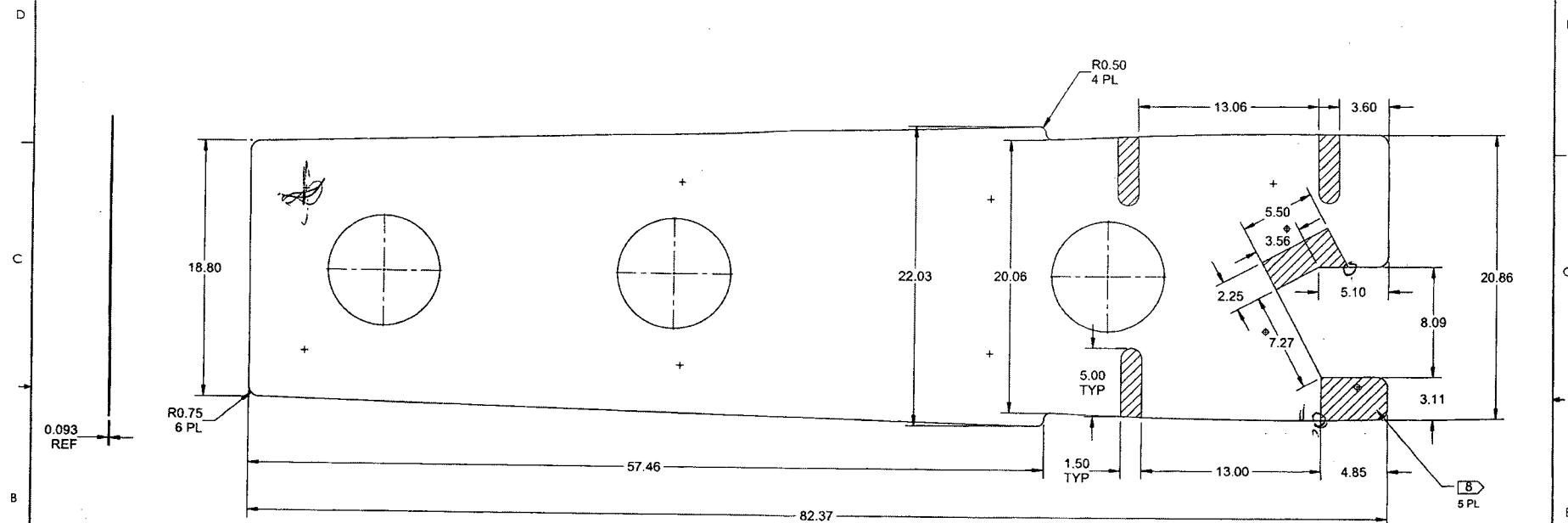
RELEASED
2012-11-29

NOTES:

- 1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 1.79 lbs
- 8) CHECK PER TEMPLATE DT8930
- 9) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER, DRAW 0.50" CROSS
ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4640	REV. C
MFG. APPR.			SHEET 7 OF 9
APPROVED		TITLE BAGGAGE PROTECTOR	SCALE
DE APPR.			NTS
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D4640-15 CEILING PROTECTOR
TEXTURED SIDE SHOWN

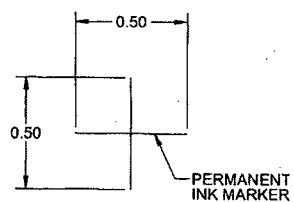
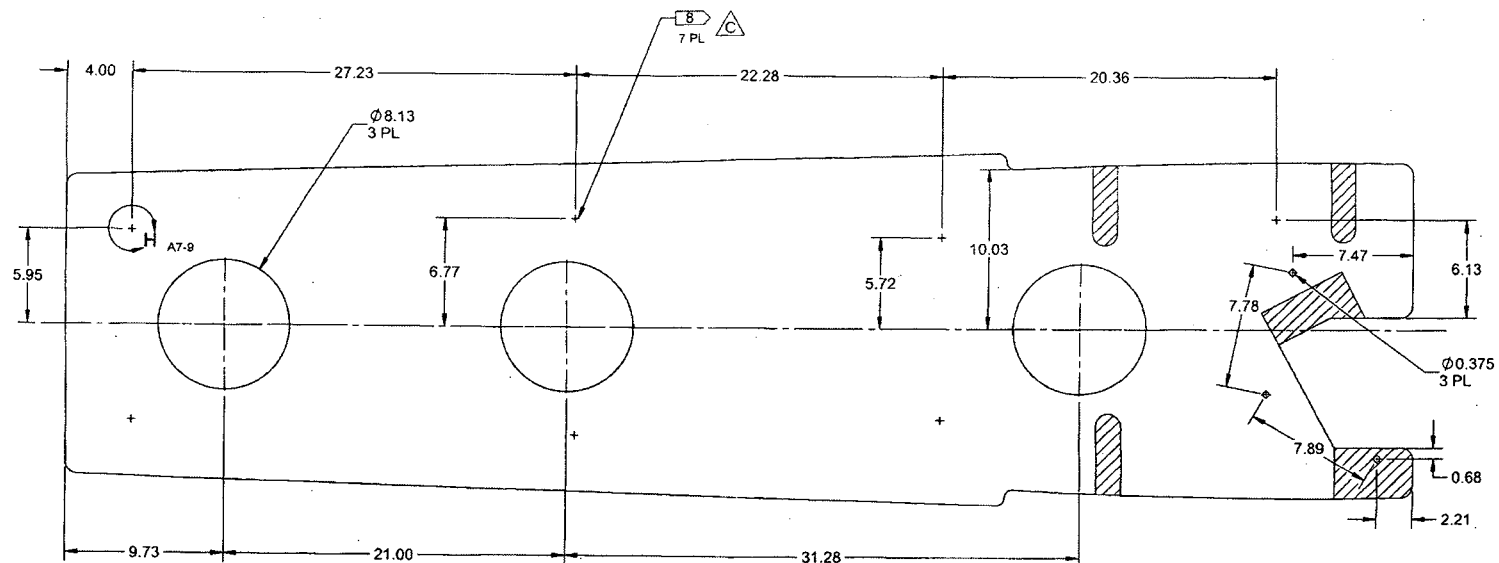
RELEASED
2012-11-29

NOTES:

- 1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 5.99 lbs (TRIMMED WEIGHT = 5.78 lbs)
- 8) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER:
- DRAW 0.50" CROSS ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER
- TRIM AND REMOVE SHADED AREAS

DESIGN	XDF	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DP	DRAWING NO.	REV. C
MFG. APPR.	DP	D4640	SHEET 8 OF 9
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	BAGGAGE PROTECTOR	NTS
DATE	12.11.22	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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95032



DETAIL H C7-9
NOT TO SCALE
TRIMMED KIT ONLY

**D4640-15 CEILING PROTECTOR
SUPPLEMENTAL VIEW**

RELEASED
2012-11-29

DESIGN	XDF	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1	DRAWING NO. D4640	REV. C
MFG. APPR.	M	SHEET 9 OF 9	
APPROVED	11	TITLE	SCALE
DE APPR.	11	BAGGAGE PROTECTOR	NTS
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Chris Provencal

From: David Shepherd <dshepherd@dartaero.com>
Sent: Friday, January 18, 2013 1:29 AM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Eric Downing'; 'David Duval'; 'L Lacelle'
Subject: RE: NCR D4640-15

Chris,

I agree that the parts are acceptable.

David

From: Chris Provencal [<mailto:cprovencal@dartaero.com>]
Sent: January-17-13 2:47 PM
To: David Shepherd
Cc: Mike Petsche; 'Eric Downing'; David Duval; 'L Lacelle'
Subject: NCR D4640-15

David,

There was an issue noticed during production of the latest batch of (36) D4640-15 protectors. When checking the parts to the template, it was noticed that there is up to a 1/8" deviation from the template along 30" on one edge. The arc of the curve is slightly off along that length, ref the attached photo. I made the decision as outlined below, and am sending this as an FYI in case you have any issues.

I've accepted the parts based on the fact that:

- Considering the function of the part, the 1/8" deviation is in line with what would be reasonable
- It has no effect on the function of the part
- Cosmetically I don't believe it will be noticeable when installed
- I am 99% sure that this is what Bell initially received and they raised no issue

The problem is in the waterjet program, which shows the deviation when overlayed with the template program. I verified that the DXFs are correct and there was no change to the program since the rev. B dwgs (currently rev. C). The problem must have been in the translation of the DXF's spline by the software. I have recreated the geometry without the spline and will provide production with an updated DXF that should have no issues.

I am wondering if this could be an issue for other files, when translating from Solidworks-> AutoCAD dxf -> Waterjet program.

-Chris